

Date: Tuesday, 11/27/2007 7:45:22 AM  
 User: Kim Johnston

## Process Sheet

|  |  |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services         | Drawing Name : BUSHING                         |
| Job Number : 35977                                     |  |
| Estimate Number : 10310                                |  |
| P.O. Number : <i>N/A</i>                               | Part Number : D26175                           |
| This Issue : 11/27/2007 S.O. No. : <i>N/A</i>          | Drawing Number : D2617 REV D2                  |
| Prsht Rev. : NC  | Project Number : N/A                           |
| First Issue : <i>N/A</i> Type : MACHINED PARTS         | Drawing Revision : D2                          |
| Previous Run : 31756                                   | Material : <i>N/A</i>                          |
| Written By : <i>[Signature]</i>                        | Due Date : 12/12/2007 Qty: <i>130</i> Um: Each |
| Checked & Approved By : <i>[Signature]</i>             |  |
| Comment : Est H 04.07.14 Reformat; added step 5 KJ/JLM |  |

Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                  |                           |
|-----|------------------|---------------------------|
| 1.0 | M6061T6T0500W058 | 6061-T6 Tube .500 x .058W |
|-----|------------------|---------------------------|



Comment: Qty: *0.0205 f(s)/Unit* Total: *2.4570 f(s)*  
*8.0205 f(s)* *3.6000 f(s)*  
 6061-T6 Round Bar 1.5"  
 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)  
 Ø0.500" tubing x 0.058" wall  
 M6061T6T0.500W.058)  
 Batch *M105 042* → *M105 042*

*BA Fmk*  
*07/12/05*

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Debur

*BA Fmk*  
*07/12/05*

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*BA Fmk*  
*07/12/05*

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*BA Fmk*  
*07.12.05*

|     |                 |                            |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*HJ 07-12-06*

*130*

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 27/12/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 11/27/2007 7:45:22 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 35977

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

F2 01/12/06 (130)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 39

11/12/06 SQ

(130A)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

22 01/12/06 (130)

Job Completion



U 01/12/06

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

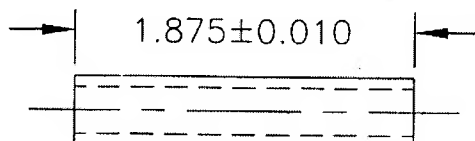
NOTE: Date & initial all entries



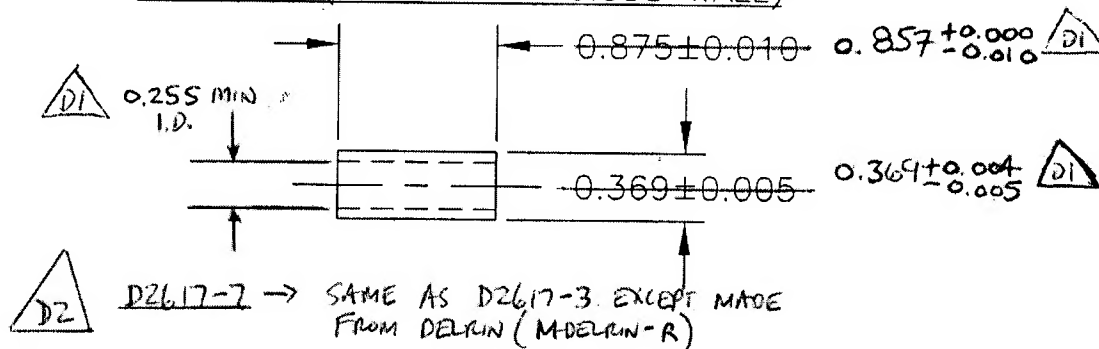


|          |          |          |                                   |   |              |
|----------|----------|----------|-----------------------------------|---|--------------|
| DESIGN   |          | DRAWN BY |                                   | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |
| BW       |          | CP       |                                   |   |              |
| CHECKED  | #        | APPROVED | #                                 | DRAWING NO.                                       | REV. D       |
|          |          |          |                                   | D2617   | SHEET 1 OF 1 |
| DATE     |          |          | TITLE                             |   | SCALE        |
| 01.07.04 |          |          | BUSHING                           |   | 1:1          |
| A        | 96.10.08 |          | NEW ISSUE                         |   |              |
| B        | 97.05.08 |          | .875 WAS 1.125                    |   |              |
| C        | 97.06.04 |          | 0.369 DIA WAS 0.375               |   |              |
| D        | 01.07.04 |          | ADD MAT'L SPEC AND TOL./DIM. NOTE |   |              |
| D1       | CP       | 04.07.12 | CORRECT TOLERANCE (NCR 779)       |   |              |

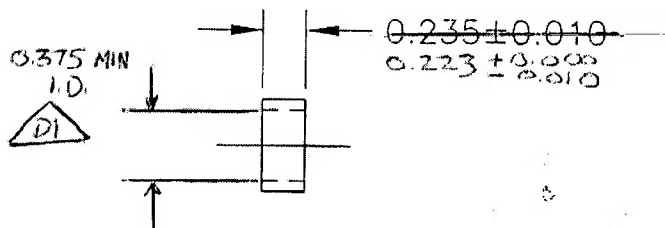
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 35977

#### NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4) OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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